

Work Order ID 78882

78882

Page 1

January-16-12 4:29:30 PM

Item ID: D3407-5 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Ring
Start Date: 16/01/2012 Start Qty: 40.00 ***40*** Cust Item ID:
Required Date: 30/01/2012 Req'd Qty: 40.00 ***40*** Customer:
Reference:

Approvals: Process Plan: M.L.J Date: 12/01/12 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3407	Rev E

100 FLOW WATER JET 0.00

100

Waterjet Memo 0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3407

Dwg Rev: E

Prog Rev: E

2-Break edges on grinder as per Dwg D3407

110 QC2- Inspect parts off machine FAI/FAIB 0.00

110

QC Memo 0.00

Quality Control

B12-1-26

[Handwritten signature] 2/01/31 *[Handwritten initials]*

B12-1-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				<u>cont</u> <u>x44</u>			
130 *130* Packaging Packaging	Identify as per dwg & Stock Location <u>ST WA</u> Memo *****STOCK IN LARGE FAB*****	0.00 0.00				<u>44x</u>		<u>SP 12-02-01</u>	
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						<u>12/2/11</u>	

12-02-11
(4)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

January-16-12 4:29:34 PM

Page 1

Work Order ID: 78882

78882

Parent Item: D3407-5

D3407-5

Parent Item Name: Ring

Start Date: 16/01/2012

Required Date: 30/01/2012

Start Qty: 40.00

Required Qty: 40.00

Comments:

IPP Rev:A New Issue 05-11-22 JLM

IPP Rev:B Now on Waterjet 08-05-14 JLM Verified By:DD

IPP Rev:C 08-08-12 revE as per dwg (ecn 08-507) DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M174B0.250X4.000

Purchased

No

100

f

0.0000

0.2666

11.22526

M174B0 250X4 000

**

B 12-1-26

17-4 SS Bar .250 X 4.00

120389

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

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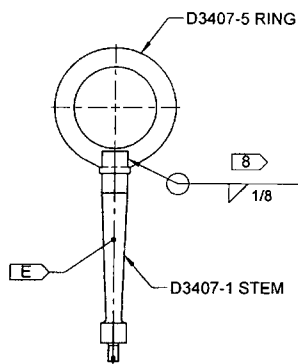
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

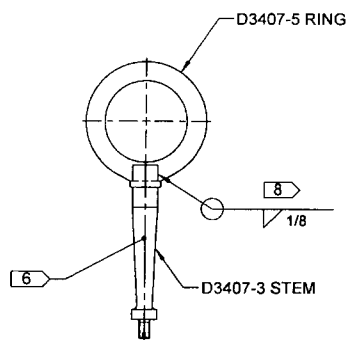
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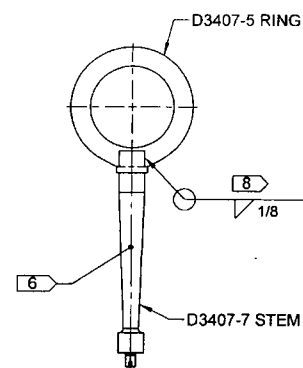
QTY -041	QTY -043	QTY -045	PART NUMBER	DESCRIPTION
X			D3407-041	TOW RING
	X		D3407-043	TOW RING
		X	D3407-045	TOW RING
1			D3407-1	STEM
	1		D3407-3	STEM
1	1	1	D3407-5	RING
		1	D3407-7	STEM



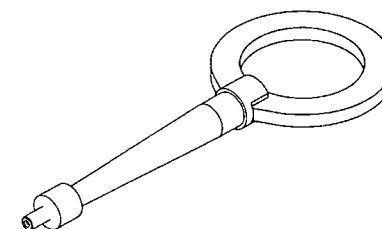
D3407-041 TOW RING



D3407-043 TOW RING



D3407-045 TOW RING



RELEASED

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3407-XXX" USING BLACK FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: D3407-041 - 0.60 lbs, D3407-043 - 0.53 lbs, D3407-045 - 0.61 lbs
 - 8) WELD PER DART QSI 004 ON ALL EDGES BETWEEN STEM AND RING

SHOP COPY
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ENGINEERING
UNCONTROLLED COPY
SUBJECT TO CHANGE

WITH NOTICE
WORK ORDER

NO. 78882 M.C.J
12/01/16

REV.	DESCRIPTION	BY	DATE
E	ADD D3407-045 (ZN B2-1, D8-1); ADD D3407-7 (ZN B6-5); REVISED NOTE 6 TO ADD IDENTIFICATION (ZN A5-1); REASON: PRODUCTION FACILITY	PH	08.07.23
D	D3407-1/-3 SLOT WAS ROUND NOW FLAT FOR ASSEMBLY WITH D3407-5 (ZN C2-2, C2-3); D3407-5 WAS ROUND NOW FLAT ON ONE END FOR ASSEMBLY WITH D3407-1/-3 (ZN B6-4); REASON: PRODUCTION FACILITY	PH	08.04.07
C	-1/-3 LONGER FOR FIT W/WASHER	CP	05.09.09
B	UPDATE DIAMETER, THREAD CLASS ADDED	CP	05.06.17
A	NEW ISSUE	CP	05.03.16
DESIGN	DART AEROSPACE USA, INC. PORT HADLOCK, WA		
DRAWN	DRAWING NO. D3407		
CHECKED	REV. E		
MFG. APPR.	SHEET 1 OF 5		
APPROVED	TITLE TOW RING		
DE APPR.	SCALE NTS		
DATE	08.07.23		

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

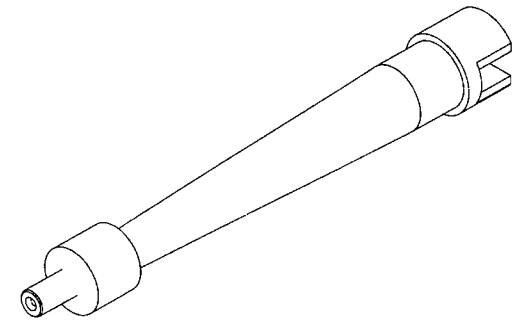
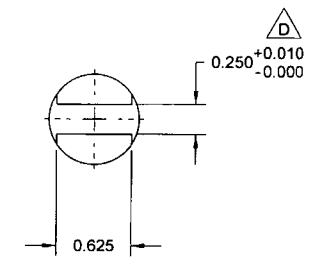
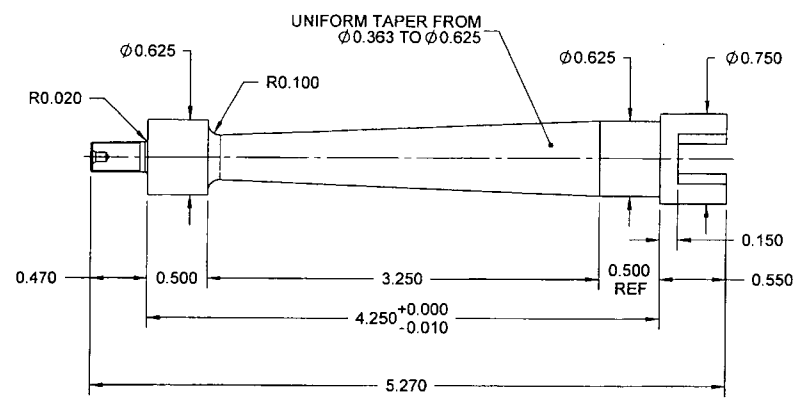
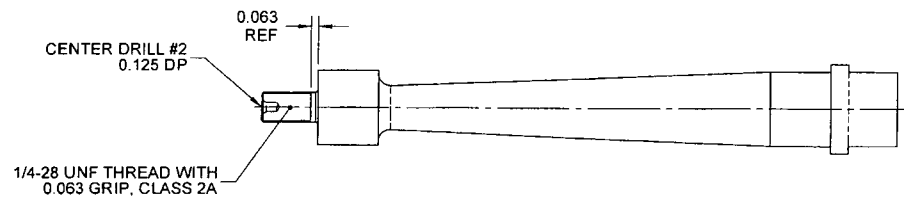
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

78882



D3407-1 STEM

RELEASED
06-05-21

- NOTES:**
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.33 lbs

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3407	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TOW RING	NTS
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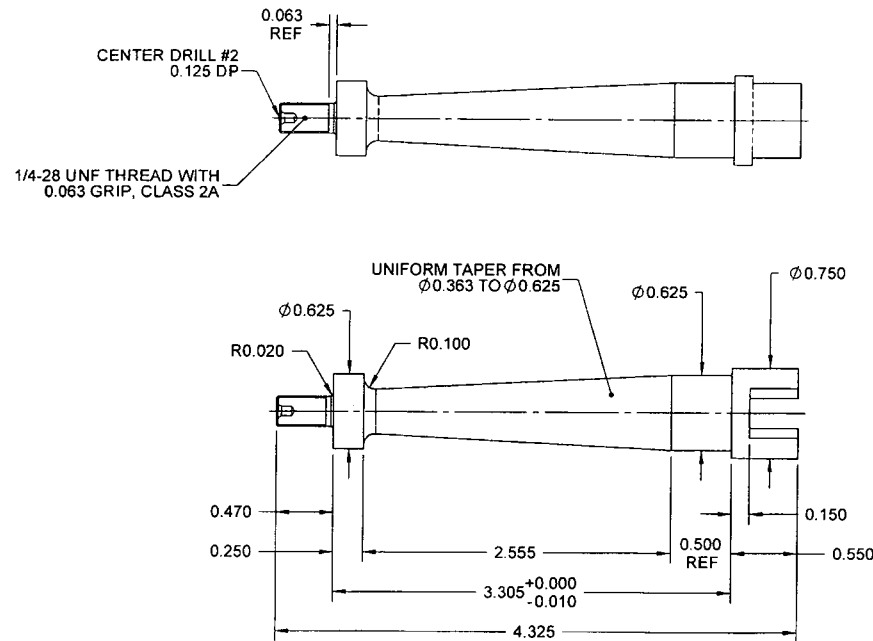
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

78802



D3407-3 STEM

- NOTES:**
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.27 lbs

DESIGN	40	DART AEROSPACE USA, INC.	
DRAWN	1/24	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3407	SHEET 3 OF 5
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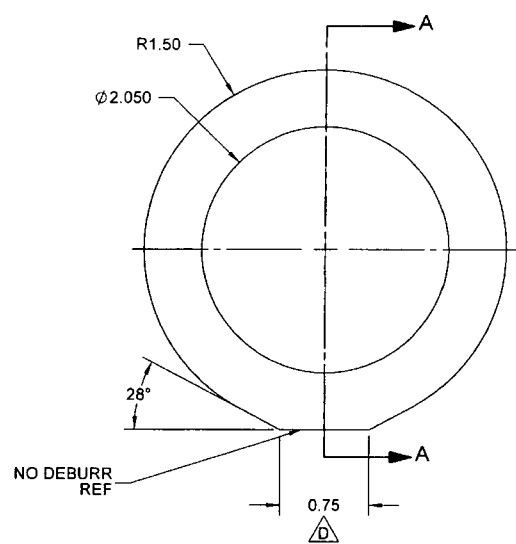
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

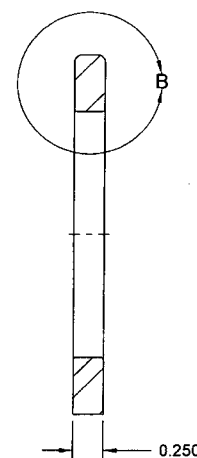
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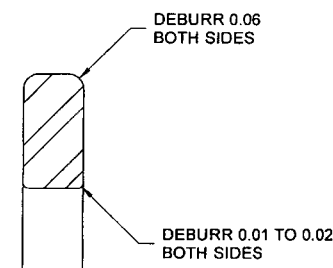
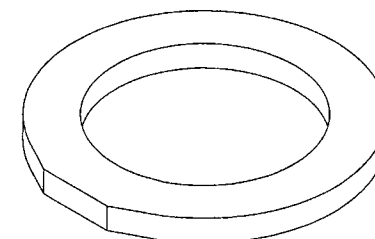
78882



D3407-5 RING



SECTION A-A



**DETAIL B
SCALE 2X**

RELEASED
06-06-01/11/12

- NOTES:**
- 1) MATERIAL: 17-4 PH SS BAR PER AMS 5604/5643 (REF. DART SPEC M17-4-B)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.27 lbs

DESIGN	92	DART AEROSPACE USA, INC.	
DRAWN	1/81	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3407	SHEET 4 OF 5
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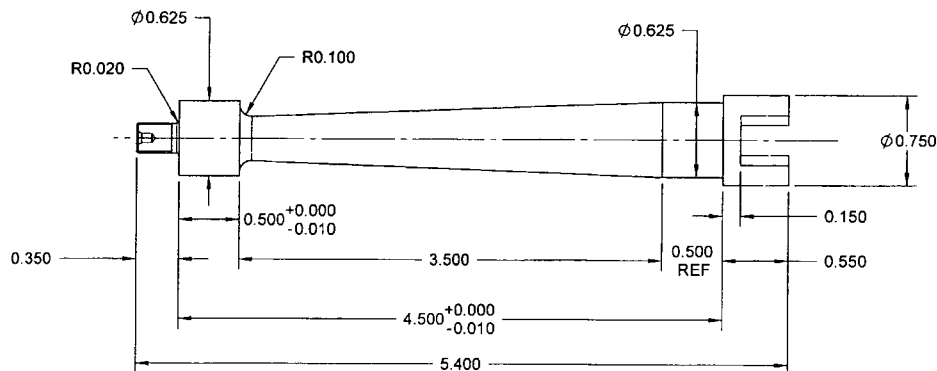
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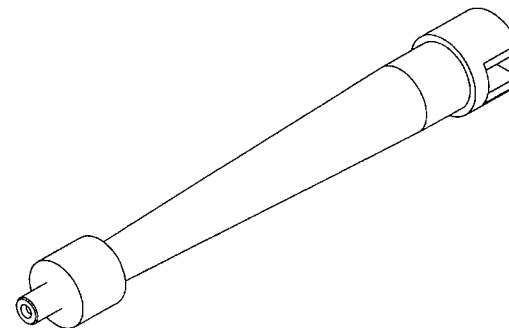
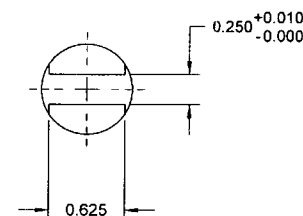
78082

0.063
REF
CENTER DRILL #2
0.125 DP

1/4-28 UNF THREAD WITH
0.063 GRIP, CLASS 2A



E D3407-7 STEM



- NOTES:**
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.34 lbs

RELEASED
06-04-01 MJP

DESIGN	AJS	DART AEROSPACE USA, INC.	
DRAWN	JPH	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3407	SHEET 5 OF 5
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